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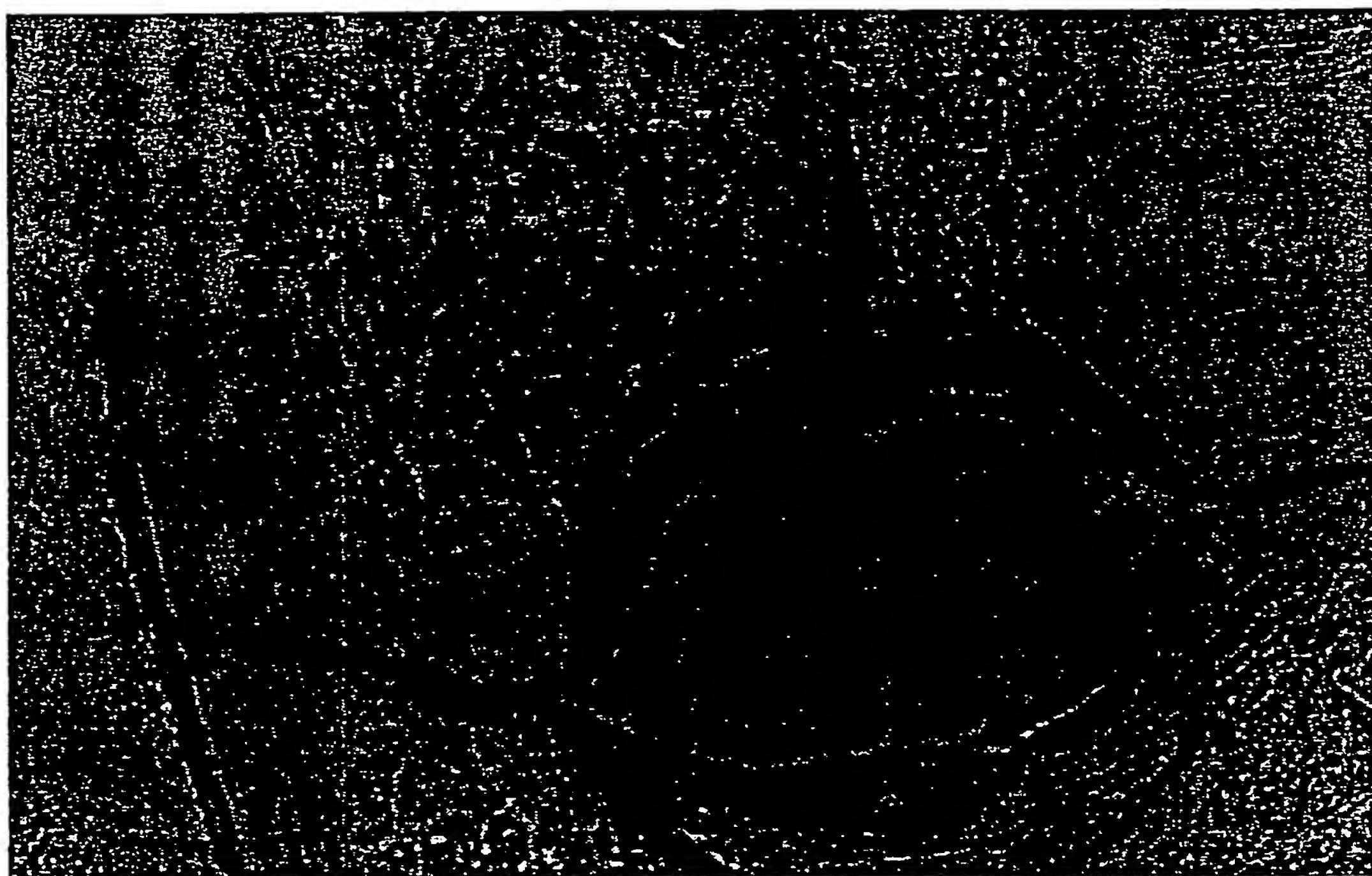
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Sample code	average perforation diameter ( $\mu\text{m}$ )	appoximate spacing between perforations in machine direction (mm)	transverse direction (mm)	spacing between perforations in	in perforated area	approximate perforation density (perforations/ $\text{m}^2$ )	puls frequency (kHz)	galvo speed (mm/s)	start positioning	gpa1	delay1	wpa1	gpa2	delay2
110/10	400	10	10	10 000	3	0.55	4000	x-4; y-160	x=4; Y=160	x=-4; y=160	1	x=4; y=-160	x=-4; y=-160	1
110/20	400	10	20	5 000	1	0.26	4000	x-4; y-160	x=4; Y=160	x=-4; y=160	50	x=4; y=-160	x=-4; y=-160	50
120/10	400	20	10	5 000	3	0.55	4000	x-4; y-160	x=4; Y=160	x=-4; y=160	150	x=4; y=-160	x=-4; y=-160	150
120/20	400	20	20	2 500	1	0.26	4000	x-4; y-160	x=4; Y=160	x=-4; y=160	150	x=4; y=-160	x=-4; y=-160	150
110/10	600	10	10	10 000	5	0.55	4000	x-4; y-160	x=4; Y=160	x=-4; y=160	1	x=4; y=-160	x=-4; y=-160	1
110/20	600	10	20	5 000	2	0.26	4000	x-4; y-160	x=4; Y=160	x=-4; y=160	30	x=4; y=-160	x=-4; y=-160	30
120/10	600	20	10	5 000	5	0.55	4000	x-4; y-160	x=4; Y=160	x=-4; y=160	120	x=4; y=-160	x=-4; y=-160	120
120/20	600	20	20	2 500	2	0.26	4000	x-4; y-160	x=4; Y=160	x=-4; y=160	150	x=4; y=-160	x=-4; y=-160	150
110/10	800	10	10	10 000	7	0.55	4000	x-4; y-160	x=4; Y=160	x=-4; y=160	1	x=4; y=-160	x=-4; y=-160	1
110/20	800	10	20	5 000	3	0.3	4000	x-4; y-160	x=4; Y=160	x=-4; y=160	1	x=4; y=-160	x=-4; y=-160	1
120/10	800	20	10	5 000	7	0.55	4000	x-4; y-160	x=4; Y=160	x=-4; y=160	150	x=4; y=-160	x=-4; y=-160	150
120/20	800	20	20	2 500	3	0.3	4000	x-4; y-160	x=4; Y=160	x=-4; y=160	150	x=4; y=-160	x=-4; y=-160	150

Sample code	Air pockets after stuffing	Surface craters after cooking	Removal of the net	Additional remarks
Standard	partially palm sized air pockets	essentially all hams show surface craters with diameters of up to 10 cm	o.k.	
8/20/20	15 % of the hams show air pockets with diameters ranging from 1cm to 4 cm	10 % of the hams show surface craters, 6 % require downgrading	o.k.	essentially all hams show pronounced surface nipples
6/10/10	2 % of the hams show small air pockets	essentially no surface craters which would require downgrading	o.k.	minor surface nipples, difficult to detect visually
4/10/10	5 % of the hams show small air pockets	3 % of the hams show surface craters; about 1-2 % require downgrading (border-line cases)	o.k.	practically no surface nipples
2/10/10	15 % of the hams show big air pockets	12 % of the hams show surface craters, 8 % require downgrading	o.k.	no surface nipples

Figure 2

Figure 3



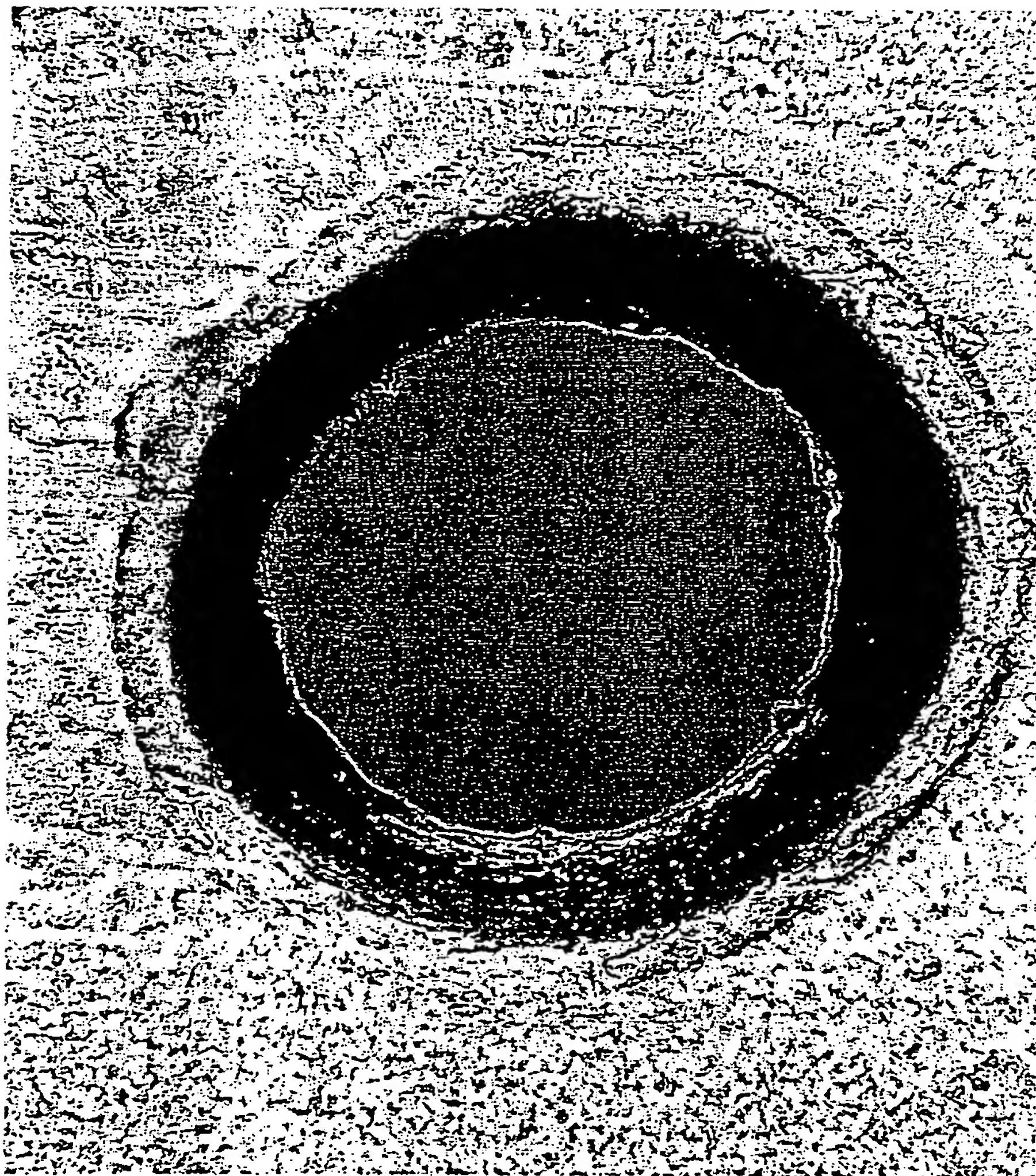


Figure 4

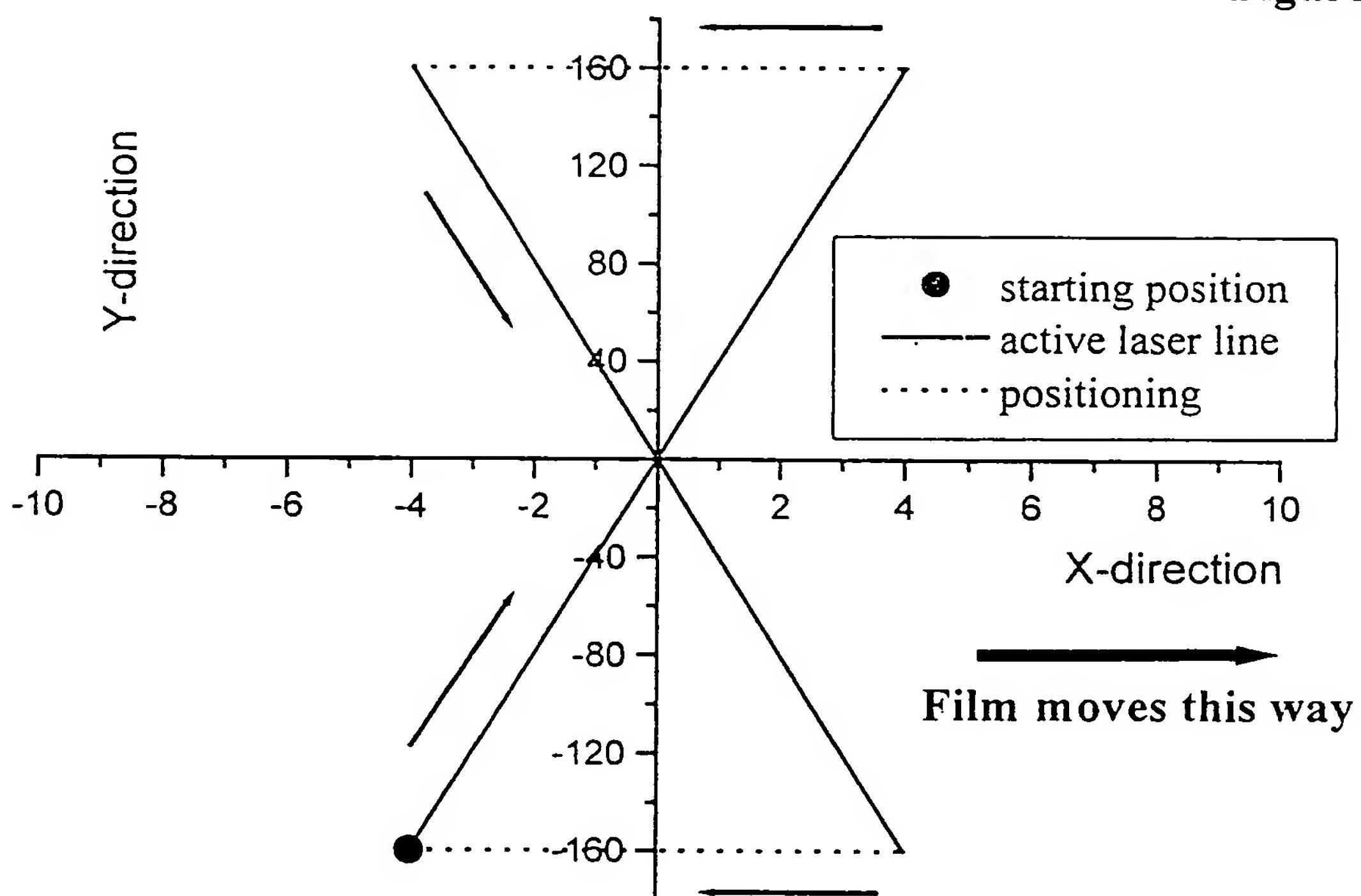
**Figure 5**

Figure 6

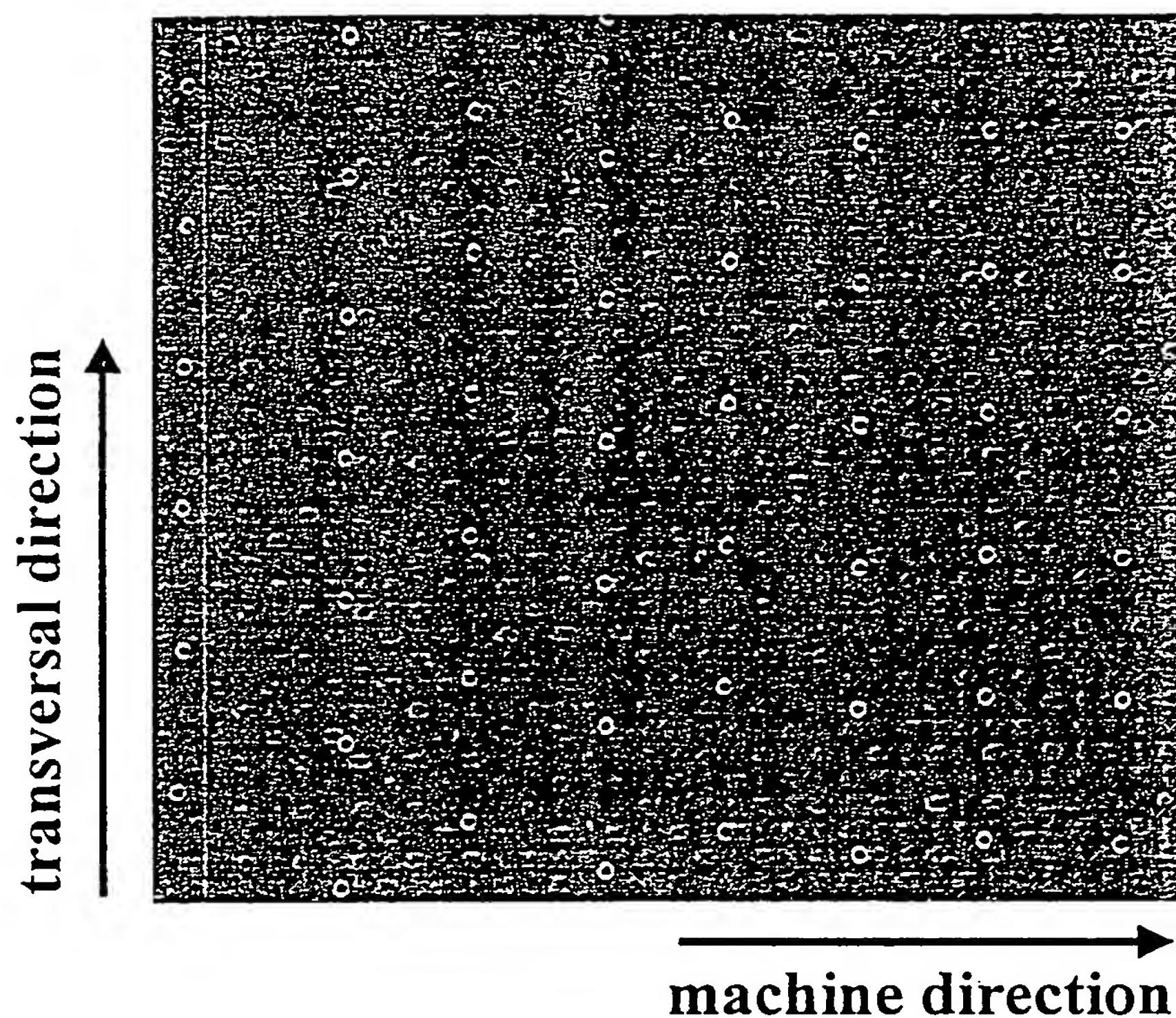


Figure 7

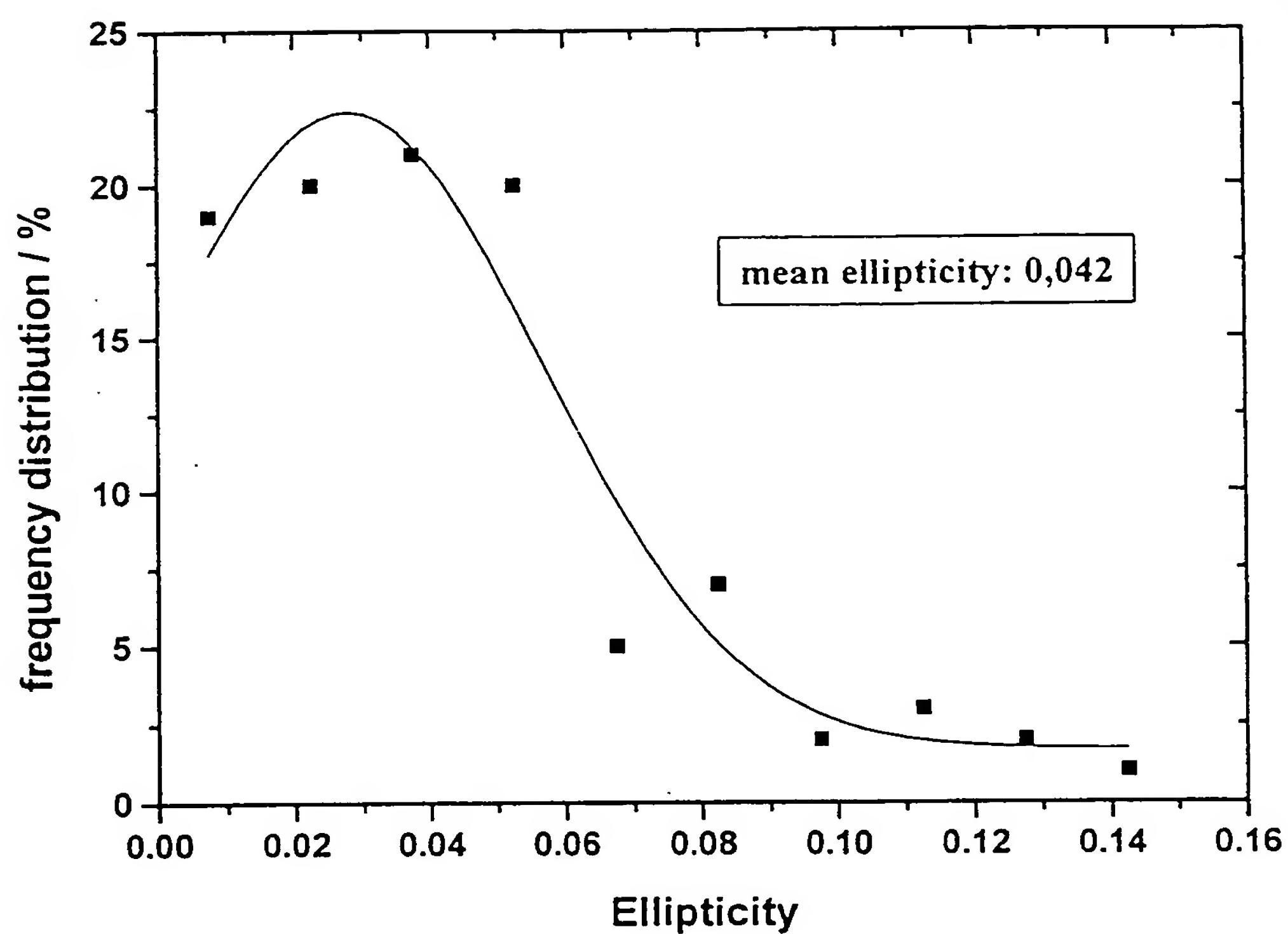
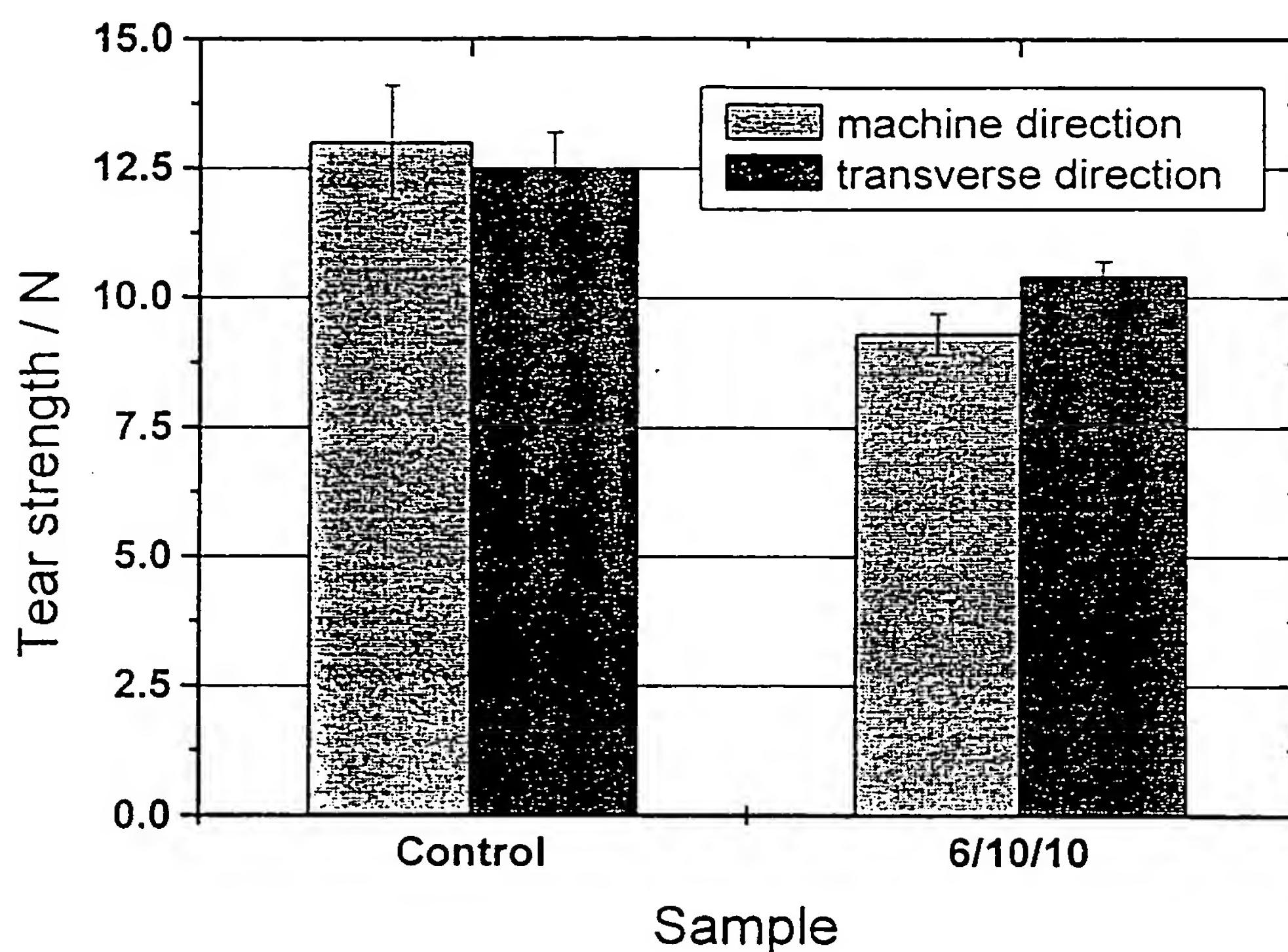
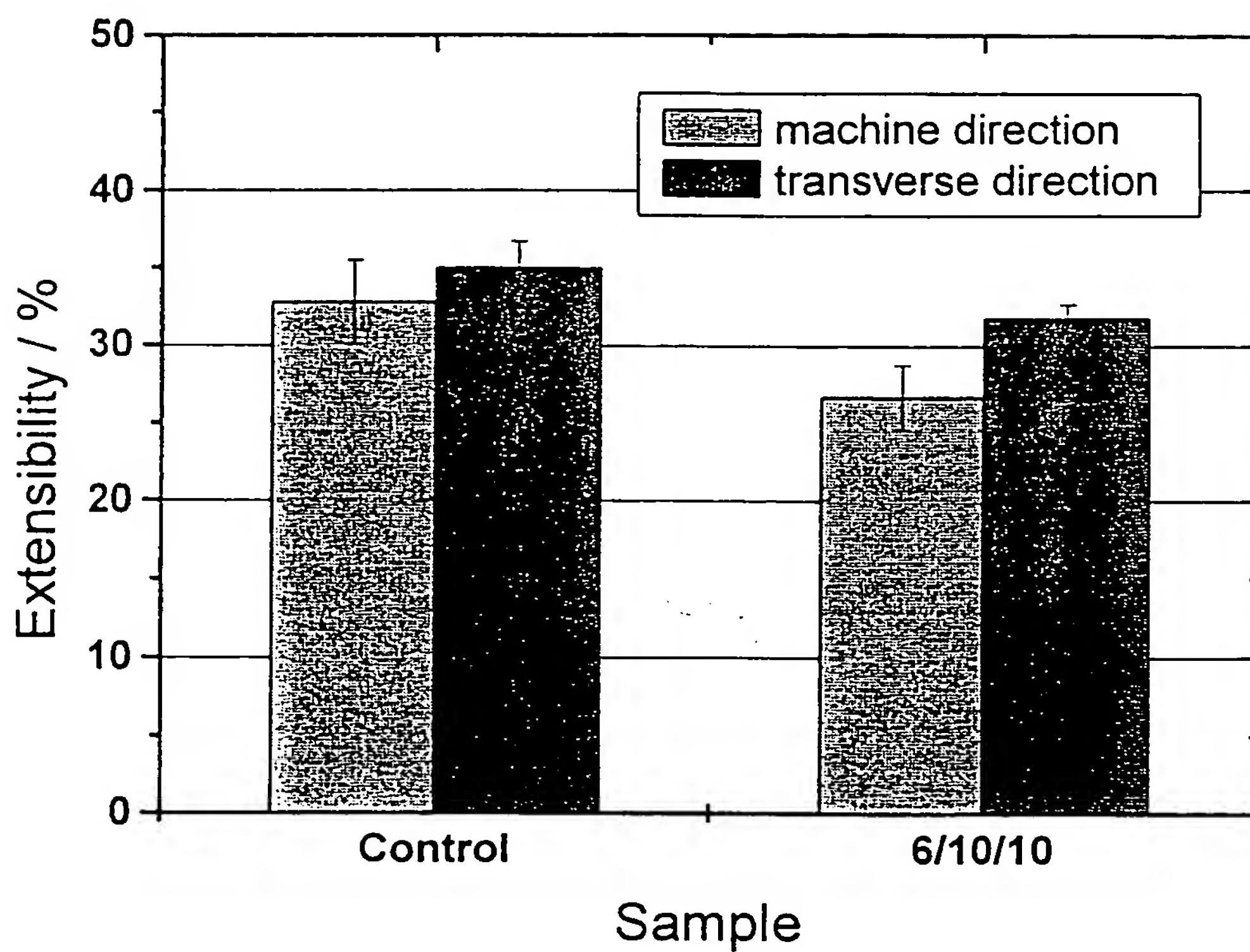
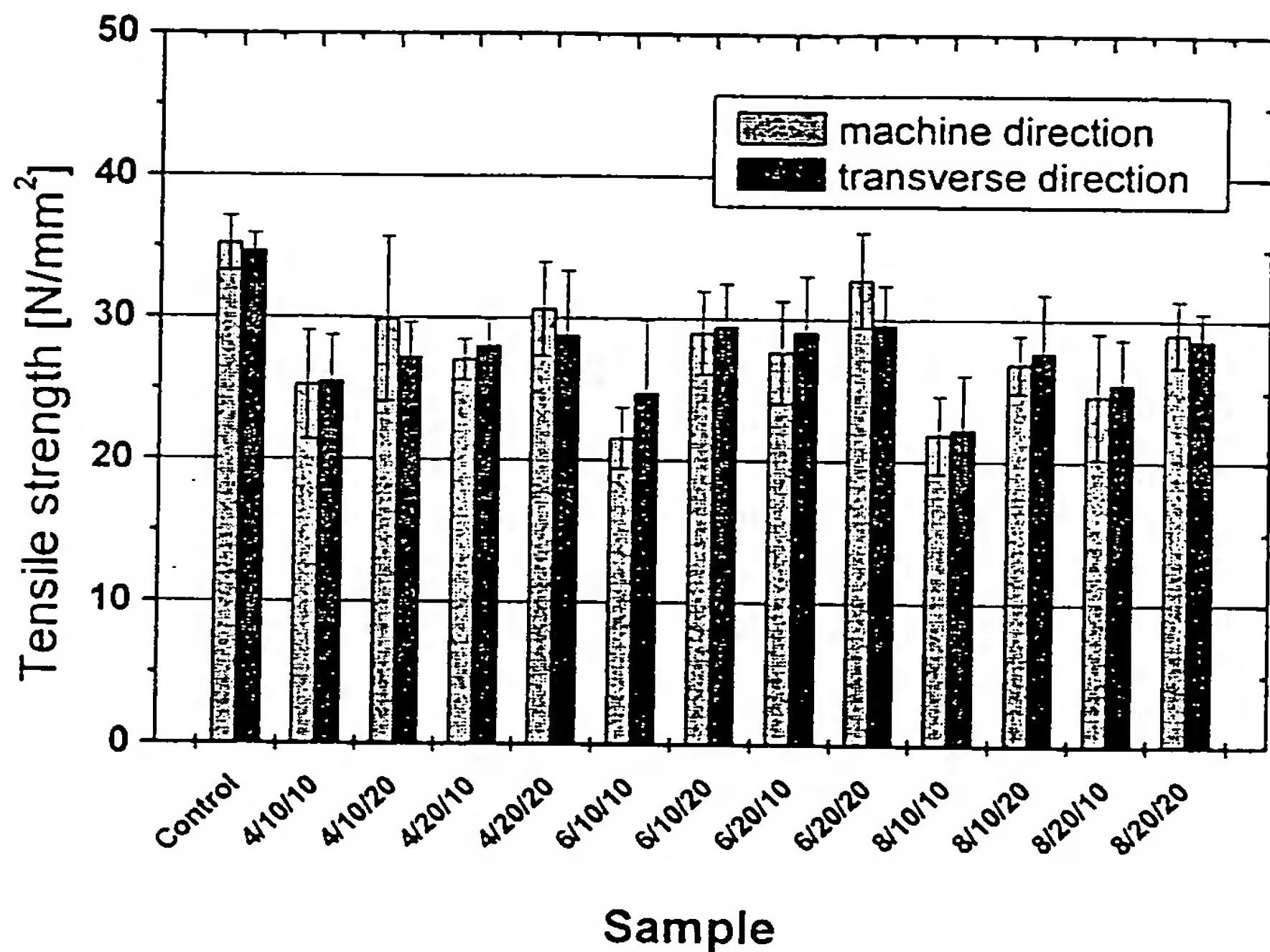


Figure 8



**Figure 9**

**Figure 10**

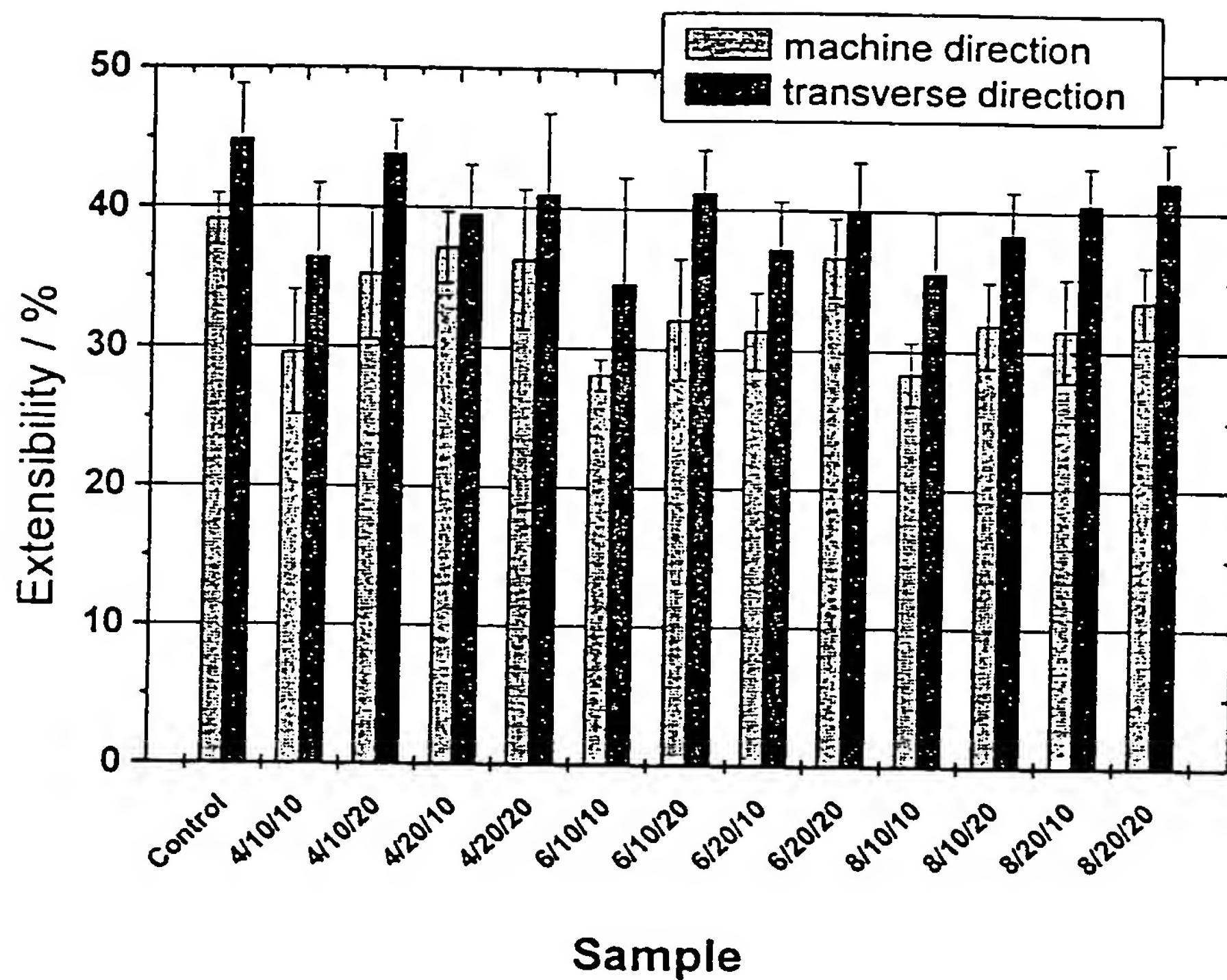


Figure 11

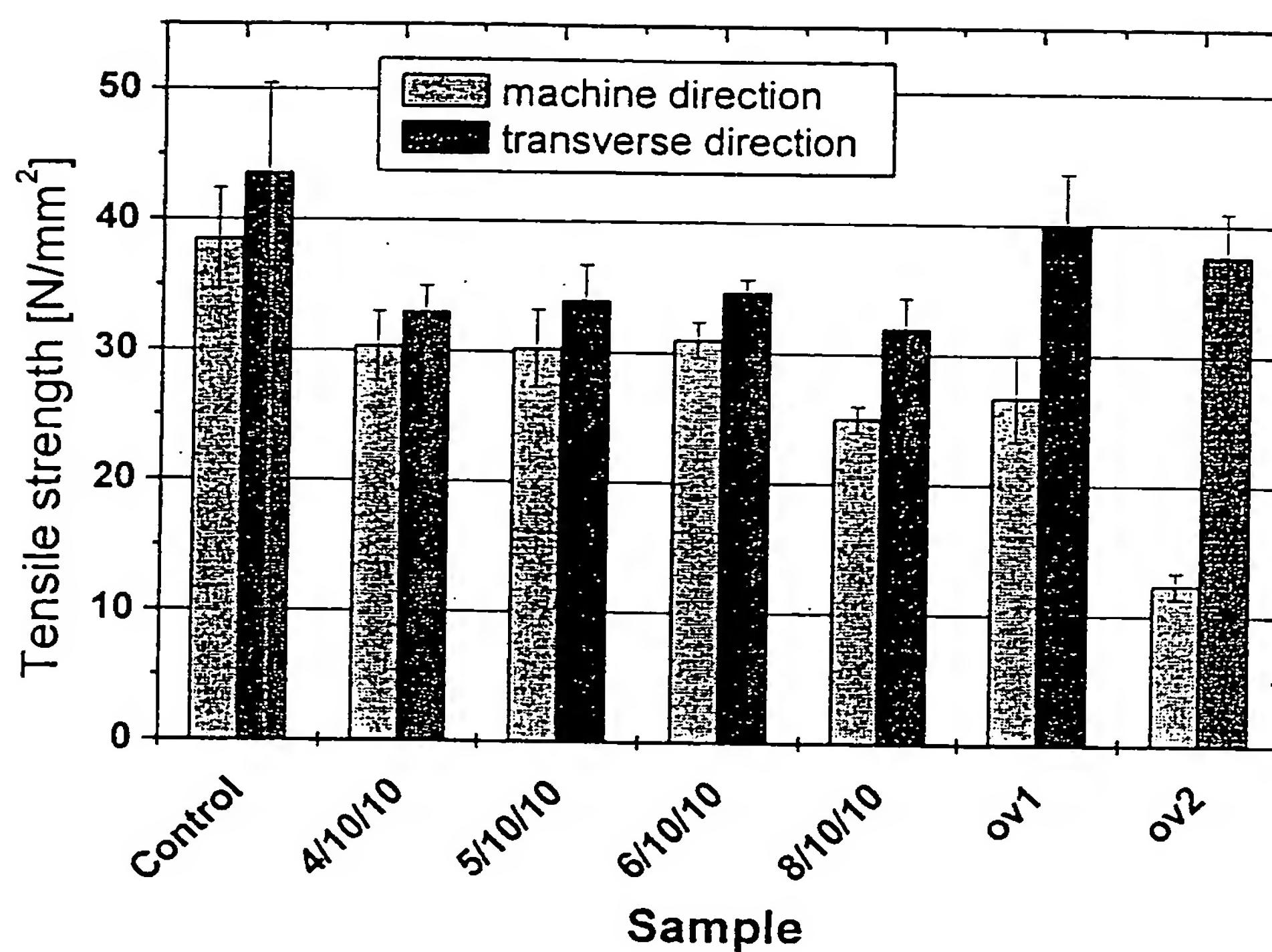
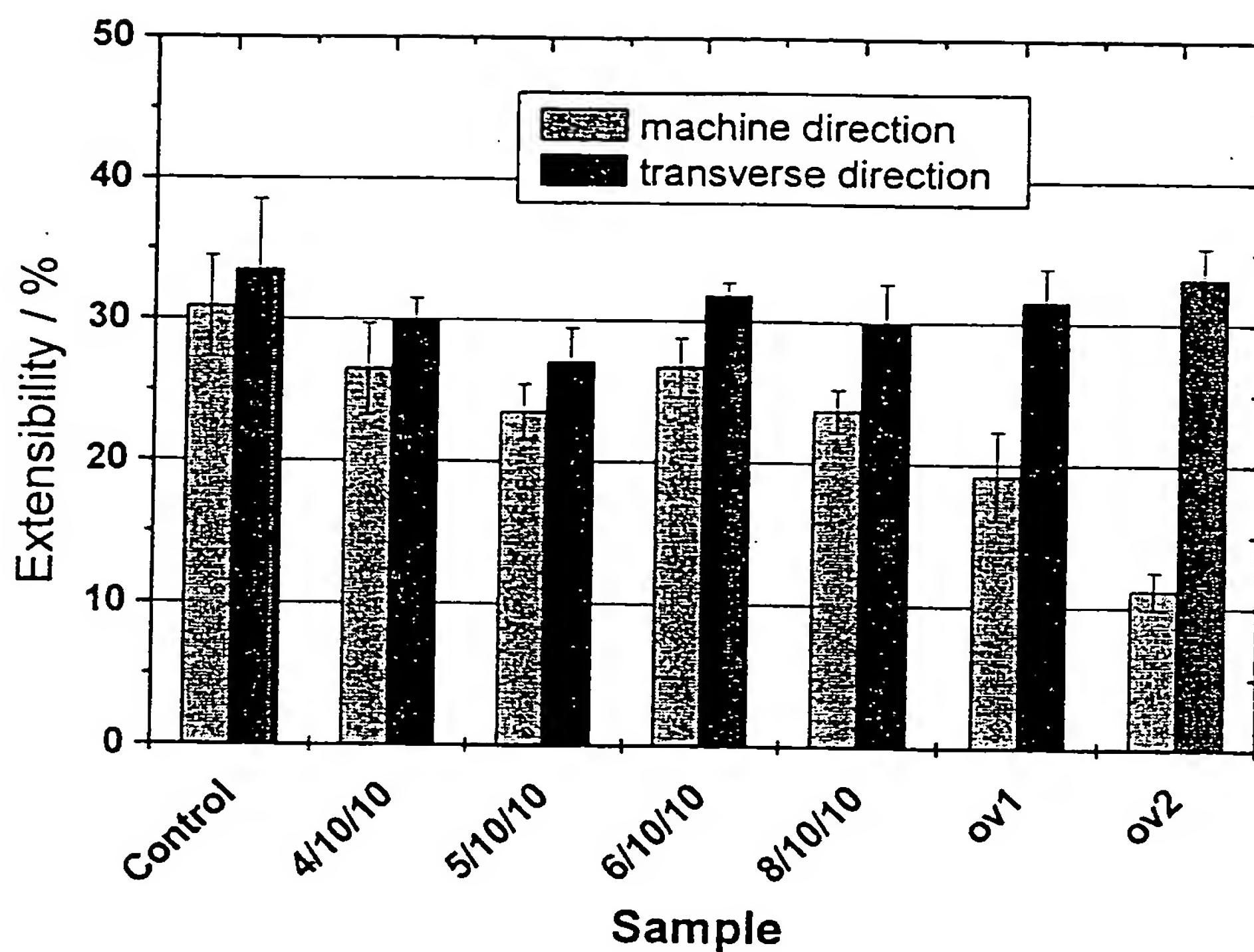
**Figure 12**

Figure 13



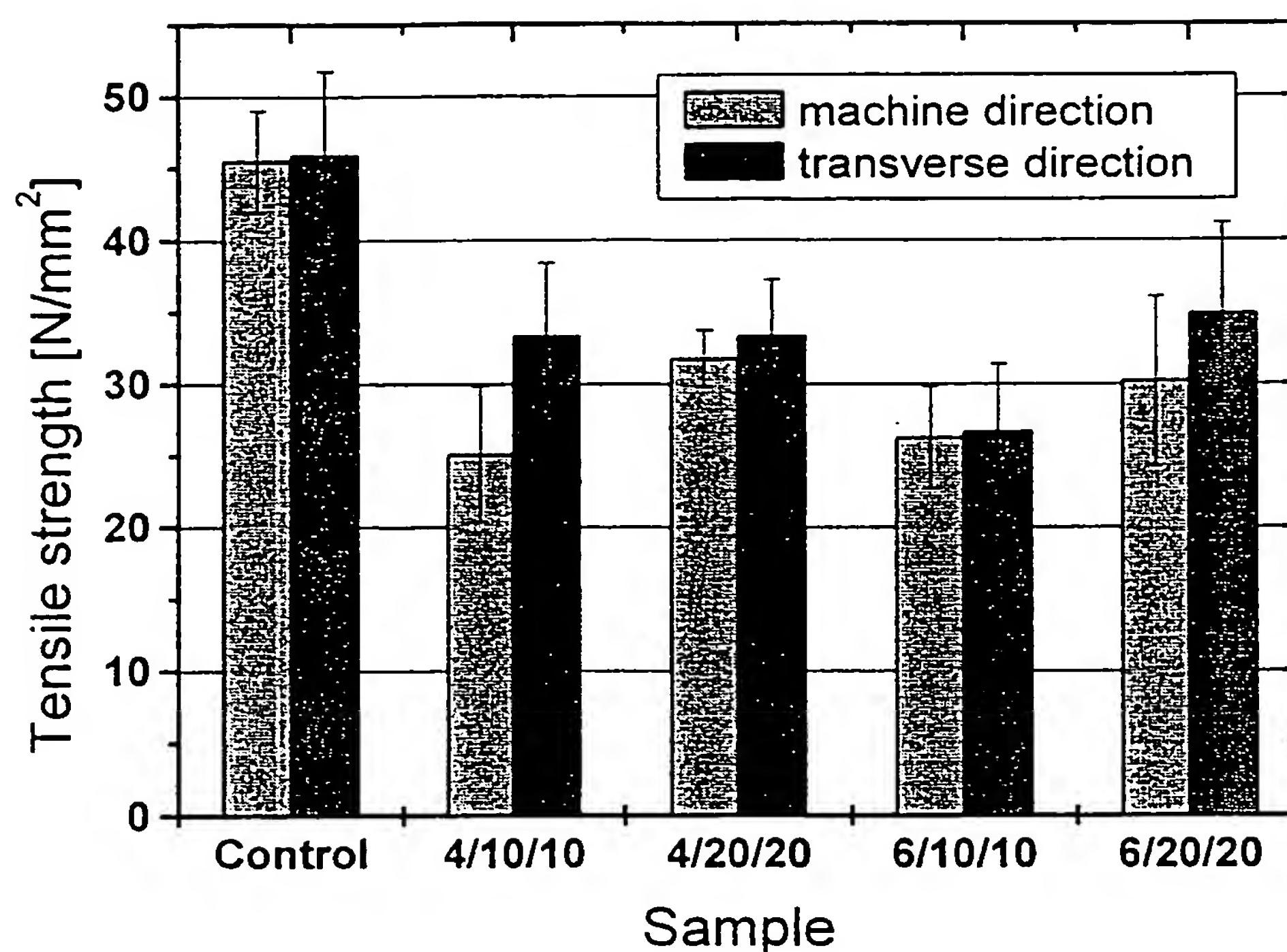
**Figure 14**

Figure 15

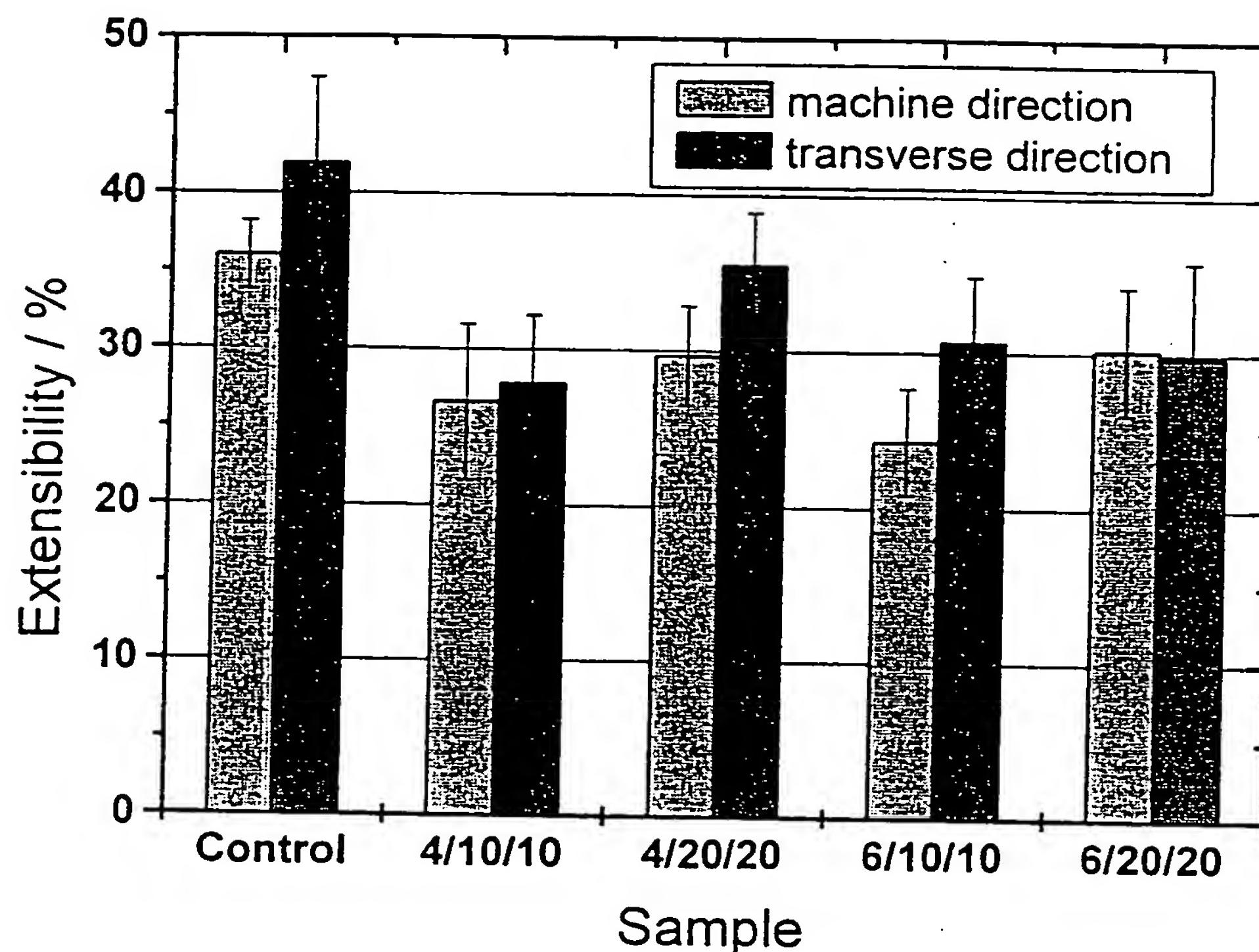
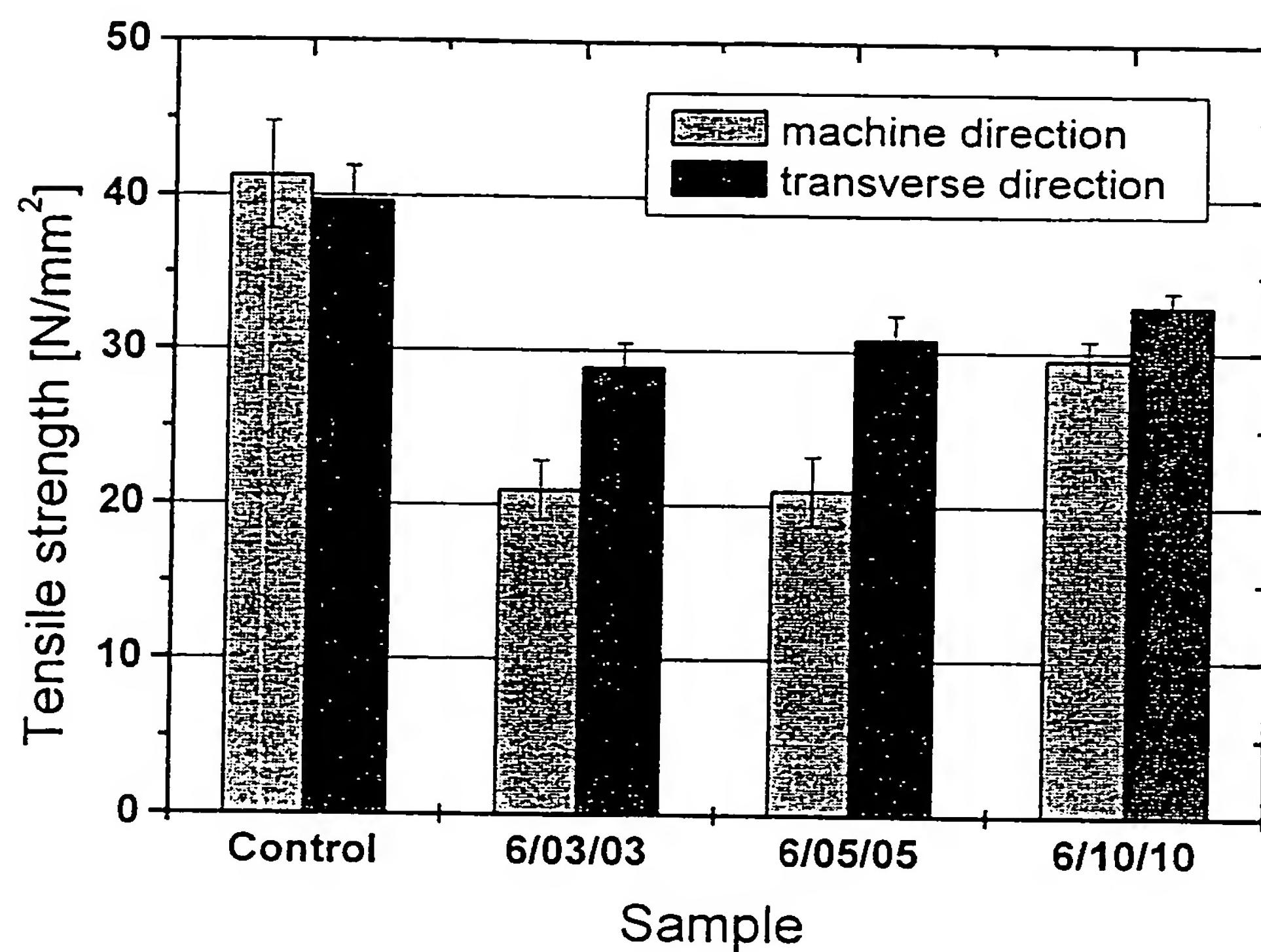


Figure 16



**Figure 17**